

Date: User: Tuesday, 07/04/2009 10:18:55 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

: 46960 : 10330

P.O. Number

This Issue

: 07/04/2009 : NC Prsht Rev.

First Issue

Previous Run

: // : 43599 Type

S.O. No. :

: SMALL /MED FAB

Part Number

Drawing Name

: D2746

: WEARSHOE

: D2746 REV C

Drawing Number Project Number

: N/A : C Drawing Revision

Material **Due Date**

: 30/04/2009

Qty:

10 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev:

Re-format KJ E 06-03-21 as Per Rev C JLM

Est Rev: Est Rev:

F 06-06-12

Now On Waterjet JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S20GA

1010/1025 SHEET

Comment: Qty.:

0.4263 sf(s)/Unit Total:

4.2630 sf(s)

1010/1025/A21/6aA .040" SHEET

(M1010S20GA)

Batch: 110368

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2746

Dwg Rev:_

Prog Rev:_

2-Deburr if necessary

3.0



NSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

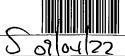
QC8

SECOND CHECK





Comment: SECOND CHECK



SMALL FAB 1 5.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.



W/O:				WO	RK ORDER CHAN	GES			**		
DATE	STEP		PRO	CEDURE CHAI			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			1						i		
						-					
Part No):		PAR #:	Fault Categ	Jory:	NC	R: Yes	No DQA	:	Date:	
			ļ		ı:						
NCR:			V	VORK ORDE	R NON-CONFORM	IANCI	E (NCR)			
DATE											
DATE	STEP	Descriptio				ction B	Sign &	Verifica		Approval	Approva
DATE	STEP	Descriptio Section		Initial Chief Eng	Corrective Action Se Action Description Chief Eng		Sign & Date	Verifica Sectio		Approval Chief Eng	Approva QC Inspect
DATE	STEP			Initial	Action Description			1			
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DATE	STEP			Initial	Action Description			1			
DATE	STEP			Initial	Action Description			1			
DATE	STEP			Initial	Action Description			1			
DATE	STEP			Initial	Action Description			1			

NOTE: Date & initial all entries

Tuesday, 07/04/2009 10:18:55 AM Date: User: Julie Dawson **Process Sheet Drawing Name: WEARSHOE** Customer: CU-DAR001 Dart Helicopters Services Job Number: 46960 Part Number: D2746 Job Number: Seq. #: **Machine Or Operation: Description:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE So 09/04/24 1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746 7.0 QC5 INSPECT WORK TO CURRENT STEP WORK TO CURRENT STEP POWDER COATING 8.0 POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 m 109 091 Comment: POWDER COATING START TIME: **OVEN TEMPERATURE:** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location FINAL INSPECTION/W/O RELEÁSE 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

	•								
W/O:			V	VORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:	į	
								; ;	
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	\ :	Date:	
	Re	solution:	Disposit	tion:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR	()			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	+6960
Description: Wearshoe	Part Number:	D2746
Inspection Dwg: D2746 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST								
		X First Art	icle	Prot	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments	
0.300	+/-0.010	205,	⊘ 7					
1.885	+/-0.010	1.883	≫					
5.450	+/-0.010	5.453	X 2					
10.900	+/-0.010	10,900	>				_	
				,				
] [• • • • •						
Measured by:	B	Audited by:	 4	\	Prototype A	N/A		
Date:	26-4-9	Date:	<u>Ala</u>	122		Date:	N/A	
Rev Date Change Revised by Approved								

A 06.07.07 New Issue

H:\FORMS\Quality Assurance\approved QA\FAI revD





1.885

1.937

06.01.12 ENLARGE HOLES TO IMPROVE FIT	06.01.12	C	
RE-DESIGN	98.08.18	В	
NEW ISSUE	98.04.16	Α	
WEARSHOE 1:8		06.01.12	
TITLE SCALE		DATE	
D2746 SHEET 1 OF 1	#	#	
DRAWING NO. REV. C	APPROVED //	CHECKED //	
PORT HADLOCK, WA	FH	<i>[4]</i>	
DART AEROSPACE USA. INC.	DRAWN BY	DESIGN	

		BENDING [DETAIL	∕— DET. B
	A -			
0.300-	A	MATERIAL:	AISI 1010-1025 OR A OR CSA G40-21, 38W, SERIES STEEL, 20 GAU	STM A36/A366/A1008 /44W/50W/60W/70W GE (0.040 THICK)
R0.110	-R0.375 15' -R0.375 UNCO		0.040 JOGGLE	R1.62
0.300 0.185	ENGINEE ORK O	SHOP COPY	- JOGGLE	SECTION A-A
<u>DETAIL A</u>	LLD COF	COPY <u>DETAIL</u>	<u>. В</u>	

FLAT PATTERN

21.800

DET. A

16.350

5.450

10.900

NOTES MATERIAL:

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PURPOSE OR COPIED

지 한 AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,

38W/44W/50W/60W/70W SERIES STEEL,

20 GAUGE (0.040 THICK)

1.450

FINISH: 2)

POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3

3) ALL DIMENSIONS ARE IN INCHES

R0.063 (TYP) -

RO.25 TOOLING NOTCH (TYP)

- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21